Work Orde March-03-14 12		1038			*114038*											
Revision ID:	D3648-041 Tunnel Assy				Accept	*N900	*N900040			Setup	Start Stop		S1* S2*			
Start Date: Required Date: Reference:	3/03/14 3/17/14		ty: 1.00 (ty: 1.00)	*1* *1*		Cust Item :	ID:									
Approvals:	Process Plan	n: ML	5	Date: <u>W-03-03</u>	Tooling: _ SPC (Y/N):	D			Run	Start Stop		R1* R2*				
Sequence ID/ Work Center II		Operation Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp			
Draw Nbr	Revi	sion Nbr														
D3648	Rev	$_{\mathrm{B}}$ \checkmark														
100		Pick Kit			0.00							_				
100 Packaging Packaging			Memo		0.00						F.	F	14-09-15			
¹¹⁰ *11∩*	•	Small Fab			0.00				,		<u>-</u>	=	14-09-15			
Small Fab			Memo		0.00						工 i.		14-07-13			
Small Fab			1-Assemble D3648 with	as per dwg D36482- Seal ma Proseal 700 fire wall sealant	ating surface and all gap batch:											
¹²⁰ *12 ∩*		QC5- Inspe	ect part comp	leteness to step on W/O	0.00				1			DAS 38 9-89	14-9-14			
QC			Memo		0.00											

Quality Control

DQA:	Date:											TOACT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT	ΓΕ			AEROSPACE
QA Closed:		Date:							Wo	ork Order up	date only	
Work Orde	er:				DISPOSITION			AG				
					Rework			Skid-tube Cro	sstube		Water Jet	Engineering
Part No.					Scrap		Machining Sm	all Fab	Prod	d. Eng. Coor.	Quality	
					Use-as-is		Therr	noforming Fir	nishing	Rec/Stor	e/Packaging	Other
NCR No.					Suspected Unapproved		Large Fab Composite				Supplier	
Root				Desci	ription of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data		:										
Equip/Tooling	_											
Handling/Pre												
Material		1										
Operator		l										
Offset/Setup	_											
Process	_											
Supplier						İ						
Training												
Transport	_				•							
Unapproved	_1		<u>. </u>			<u> </u>						
						FAL	ULT CA	TEGORY				
Landir	ng Gear			_	General] !: _ /s	\		امستناء منسا	: <u>-</u>	1,,,,,,,,,
ŀ	Bending	Not Conce	ntrio		Bend BOM/Route		4	Program		Outside Dim Over/Under		Pressure/Forced Set-up
·	Cracks	NOT CONCE	ntric		Broken/Damage/Defect	-	Grain Hardwa	1		Part Incorred		Temperature/Cure
ŀ		ink/Ripple	Maya		· • ·		4	are ion Incomplete/Unqualifi	—	Part Lost/Mi		Weld
}	Cuffs	iiik) kippie	:/ vvave	-	Burrs	\vdash	1 '	tions Incomplete/Unclear	-	Part Moved		Wrong Stock Pulled
1	_	7		\vdash	Contamination Countersink		4	gned/off center		Positioned W	/rong	TWI OIR Stock Fulled
}	Crushing Heat Treat				Cut Too Short		Mislabe			Power Loss/S	_	Other
•	Inspection Strip in Tube				Drawing	\vdash	Misrea		<u> </u>	1. 044 C. 1.033/.		0.101
	Marks/0	•		<u> </u>	Drill Holes	-	Off-set				· · · · · · · · · · · · · · · · · · ·	
		Sequence			Finish	\vdash	1	Calibration				
		wist in Tul			Fit/Function		4	Sequence				

Page 2

Insp.

Stamp

Work Order ID 114038 *114038* March-03-14 12:40:27 PM Accept Item ID: D3648-041 *N900040100* Setup Start **Revision ID:** Stop Item Name: Tunnel Assy *1* **Start Otv:** 1.00 **Start Date:** 3/03/14 **Cust Item ID:** Reg'd Oty: 1.00 Required Date: 3/17/14 *1* **Customer:** Reference: Run Start Process Plan: Tooling: Approvals: Date: Date: Stop Date: SPC (Y/N): Date: OC: Tool # Plan Reject Reject Tool ID Sequence ID/ Operation Set Up/ Accept Qty Number **Work Center ID** Code Qty Description **Run Hours** 130 Identify as per dwg & Stock Location: 0.00 *120* Packaging Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

*14**0***

Quality Control

JA4-9-16

DQA:			Date:										TOART		
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:	_		Date:							W	ork Order up	date only			
Work Orde	er:					DISPOSITION			AGAINST						
Part No. NCR No.						Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
			 	1					<u> </u>				, 		
Root			c .	· ·		ription of work order update		nitial	Action		Sign &	., .,			
Cause	+	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design	-														
Doc/Data	\dashv	:			1										
Equip/Tooling Handling/Pre	\dashv	į									·				
Material															
Operator	\dashv					·									
Offset/Setup	\dashv			,					,						
Process	\dashv												·		
Supplier	\dashv										٠				
Training	\dashv												,		
Transport	\exists										·				
Unapproved	\exists														
					\		FAI	ULT CAT	TEGORY		<u> </u>				
Landir	ng Ge	ar				General					· · · · · · · · · · · · · · · · · · ·				
	В	ending .		•		Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced		
	C	entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up		
	Cı	racks				Broken/Damage/Defect		Hardwa	are		Part Incorre	:i	Temperature/Cure		
	Cı	rimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
	Cuffs					Contamination		Instruct	tions Incomplete/Unclear		Part Moved	,	Wrong Stock Pulled		
	Cı	rushing				Countersink		Misalig	gned/off center		Positioned V	Vrong <u>\</u>	· ·		
	н	eat Treat	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
ļ	ln	spection	Strip in	Tube		Drawing		Misread	d						
	∨	larks/Cha	atter			Drill Holes		Off-set							
		urning Se	equence			Finish		Out of 0	Calibration						
	Wave/Twist in Tube					Fit/Function		Out of 9	Sequence						

Picklist Print

March-03-14 12:40:31 PM

Work Order ID: 114038

114038

Parent Item:

D3648-041

D3648-041

Parent Item Name: Tunnel Assy

Start Date: 3/03/14

Required Date: 3/17/14

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

Aft Base Assembly

IPP Rev:A New Issue 07-10-03

IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC

EC verified by: DD

IPP Rev:C ECN1162

08-04-02 DD verified by:EC

	Replacement tem ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
AN3C3A		Purchased	No			110	Each	1,166.000	40	40		.
AN3C3A									**		F	F14-09-15
		•		Location	<u>1</u>	Loc	Oty	Loc Code		•		
				ST350			1166		_		_	
		,			122141 124417		6 1160		_	40	_	
D3649-041		Manufactured	No			110	Each	1.0000	1	1		
*D3649-041 Tunnel Bottom Panel Assy	*								**		FF	14-09-13
				Location	114039	Loc	<u>Oty</u>	Loc Code				
				ST183	MARCO		1				_	
					94463		1		_		_	
D3650-041		Manufactured	No			110	Each	2.0000	1	1		
*D3650-041 Tunnel Top Panel Assembly	*								**		F	F 14-09-1
				Location	<u>l</u>	Loc	<u>Oty</u>	Loc Code				
				ST183			2		_			
	•				109596		2				-	
D3651-041		Manufactured	No			110	Each	0.0000	1	1		·
*D3651-041	*				4040				**		F	F14-09-1

DQA:	Date:											TOART				
						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:						_	V	Vork Order up	date only	<u> </u>			
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS				
Part No						Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Compos		Prod. Eng. C Rec/Store/Packa		Engineering Quality Other			
Root					Desci	ription of work order update		Initial	Δ	ction	Sign &					
Cause		Date	Step	Qty	5000.	or non-conformance		ief Eng		cription	Date	Verification	QC Inspector			
Design			ССР	Δ.,		or non-comormance	<u> </u>	iler Elig	<i>D C S S S S S S S S S S</i>	cription		Vermodelon	<u> </u>			
Doc/Data	-					<u>, '</u>				•						
Equip/Tooling Handling/Pre	-								,							
Material	-															
Operator	_												· ·			
Offset/Setup	\dashv		,													
Process	_															
Supplier	\neg															
Training																
Transport	\neg					Ŷ.										
Unapproved	\neg			:					See							
 				1	L		FAI	ULT CA1	TEGORY		1.					
Landir	ng G	ear				General		, .								
		Bending				Bend		Folio/P	rogram	Γ	Outside Dim	ensions	Pressure/Forced			
	\neg	Centre No	t Concer	ntric	1	BOM/Route		Grain			Over/Under	tolerance	Set-up			
	\neg	Cracks				Broken/Damage/Defect	广	Hardwa	re		Part Incorred	ci –	Temperature/Cure			
	\Box	Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/L	Jnqualified	Part Lost/Mi	ssing	Weld			
	Cuffs					Contamination		Instruct	ions Incomplete,	/Unclear	Part Moved		Wrong Stock Pulled			
. [Crushing					Countersink		Misalig	ned/off center	· [Positioned V	Vrong				
		Heat Trea	t	•		Cut Too Short		Mislabe	eled	` [Power Loss/	Surge	Other			
		Inspection	Strip in	Tube		Drawing		Misread	Ŀ			<u> </u>				
		Marks/Ch	atter			Drill Holes	·	Off-set		•		<u> </u>				
		Turning Se	equence			Finish		Out of (
	\	Wave/Twi	st in Tub	e		Fit/Function	Out of Sequence									

Picklist Print

March-03-14 12:40:31 PM

Page 2

Work Order ID: 114038

Parent Item:

D3648-041

Parent Item Name: Tunnel Assy

114038

D3648-041

Start Date: 3/03/14

Required Date: 3/17/14

Start Qty: 1.00

**

Required Qty: 1.00

NAS1149C0363R

Purchased

100

Each

976.0000

40

NAS1149C0363R

Location		Loc Oty	Loc Code	
FP001	128591	698		40
	114742	698	•	
ST292		278		
	122441	278		

DQA:			Date:				DART								
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / L		Wor	k Order up	date only - [_	AEROSPACE
			Dute.												
Work Orde	er:					DISPOSITION									
						Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	Part No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Store/Packaging				Other
NCR N	No			-		Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Descr	ription of work order update		Initial	Ac	ction	<u> </u>	Sign &		1	
Cause	. (Date	Step	Qty		or non-conformance	ı	ief Eng	1	cription		Date	Verification	,	QC Inspector
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Operator															
Offset/Setup															
Process	Ш														
Supplier							İ								
Training															
Transport															
Unapproved										·····					·
							FA	ULT CA	TEGORY						,
Landi	ng Gea					General				Г			r		
	_	nding				Bend		1	Program		-	Outside Dim	- t		Pressure/Forced
	_		t Concer	ntric		BOM/Route		Grain			-	Over/Under	- F	-	Set-up
	_	acks				Broken/Damage/Defect	<u></u>	Hardwa				Part Incorrec	- F		Temperature/Cure
	_		k/Ripple	/Wave	\vdash	Burrs	<u> </u>	1 '	ion Incomplete/L	` !	_	Part Lost/Mi	-		Weld
	Cu					Contamination		4	tions Incomplete	· ·		art Moved	_		Wrong Stock Pulled
	_	ushing			\vdash	Countersink		1	gned/off center		_	Positioned W	· ·		
:		at Treat				Cut Too Short	<u></u>	Mislabe		Į.	F	ower Loss/	Surge		Other
	-		Strip in	Tube		Drawing		Misrea			_				
		arks/Cha				Drill Holes	_	Off-set			_		· .		
	_	_	quence		<u> </u>	Finish	<u>_</u>	4	Calibration		_				
	[]Wa	ave/Twi	st in Tub	e		Fit/Function		Out of Sequence							